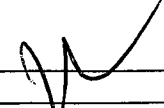


Date: Thursday, 19/04/2007 11:07:40 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 31894	
Estimate Number : 10737	
P.O. Number :	Part Number : D31261
This Issue : 19/04/2007 S.O. No. :	Drawing Number : D3126 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A1
Previous Run : 31894	Material :
Written By : 	Due Date : 20/05/2007 Qty: 5 Um: Each
Checked & Approved By :	
Comment : Est A03.01.15 New issue KJ/RF	
Est Rev:B Now On Waterjet 07-04-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S22GA	304/316 .032 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0623 sf(s)/Unit Total: 0.3113 sf(s)
 304/316 .032 Sheet

BH M102159

SAD 07/06/14

5

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3126
 Dwg Rev: A1
 Prog Rev: A1

2-Deburr if necessary

SAD 07/06/14

P/O P/BAS

5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/14

5

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

EP 07/06/14

x5

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary
 Form on CNC brake as per D3126 using Jig D3126T1 Identify as D3126-1
 Scribe Dart P/N as shown on Dwg D3126

SAD 07/06/14

⑤

SB 03/02/14

08/02/19

⑤

Date: Thursday, 19/04/2007 11:07:40 AM
User: Linda Lacelle

2

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31894

Part Number: D31261

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/02/22 (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 238*

Handwritten: AS 08/02/22

Handwritten: (X5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08/02/05

Job Completion



Handwritten: 2008/2/25

Handwritten: (5)

Date: Tuesday, 4/17/2007 3:47:20 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 31894
 Estimate Number : 10737
 P.O. Number :
 This Issue : 4/17/2007 S.O. No. :
 Prsht Rev. : NC Drawing Number : D3126 REV A1
 First Issue : / / Type : PURCHASED PARTS Project Number : N/A
 Previous Run : 25492 Drawing Revision : A1
 Written By :
 Checked & Approved By : *[Signature]*
 Comment : Est A 03.01.15 New issue KJ/RF

Part Number : D31261
 Due Date : 5/20/2007 Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: _____

Email or ship Dxf file to vendor

Laser cut per Dwg D3126 flat patern D3126-1

Material: AISI 304/316 SS sheet 0.032" thick per MIL-S-5059(Ref: Dart Spec. M304S) Annealed

Material release note required

waterjet
M304S-032
.0595"

2.0 D31261F Bracket-Flat



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Bracket

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure the material note is attached.

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on CNC brake as per D3126 using Jig D3126T1 Identify as D3126-1

Scribe Dart P/N as shown on Dwg D3126

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3126-1 PAR #: N/A Fault Category: Prod / Eng. Ass ^{made @ final} NCR: Yes No DQA: LD Date: 08/02/15
 QA: N/C Closed: JA Date: 08 02 25

NCR: <u>31891</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/06/14</u>	<u>2.0</u>	<u>Scrap one part, waterjet Pierce a hole where it was not suppose to</u>	<u>[Signature]</u>	<u>Scrap, destroy, replace modify program</u>	<u>SAD</u> <u>07/06/14</u>	<u>En</u> <u>07/06/18</u>	<u>[Signature]</u>	<u>En</u> <u>07/06/18</u>

NOTE: Date & initial all entries

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31894

Part Number: D31261

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ / NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

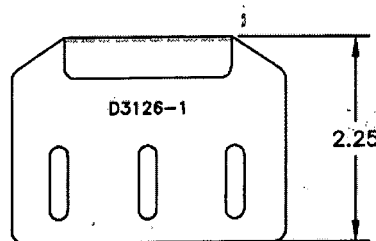
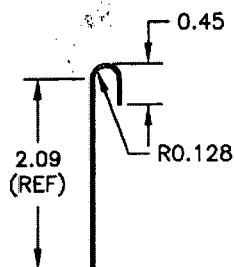
DART
SUPERCEDED BY



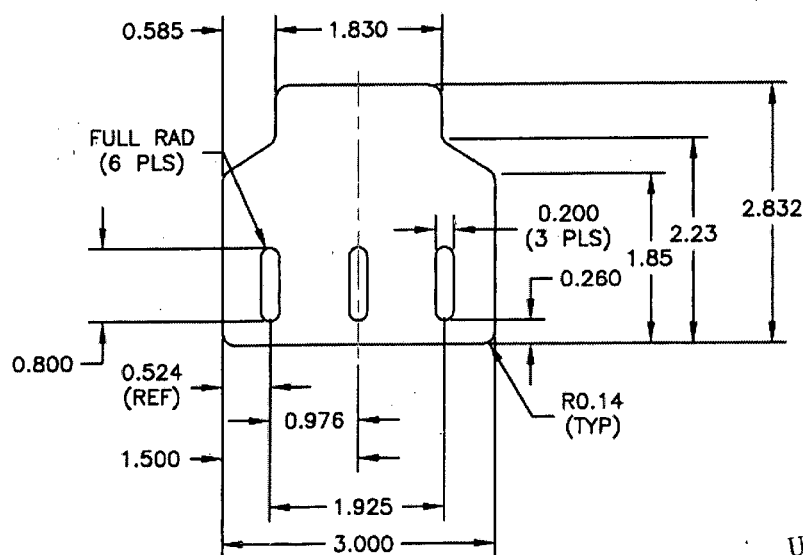
Rev. B 04.11.24 02.11.24

RELEASED
02.05.27

DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3126	REV. A SHEET 1 OF 3
DATE 02.04.17	TITLE BRACKET		SCALE 1:2
A	02.04.17	NEW ISSUE	
AI	02.09.23	ADD "ANNEALED" SPEC	



D3126-1 BRACKET
REPLACES PREMIER P/N B30-23000-265



D3126-1 BRACKET FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31894

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-1 AS SHOWN

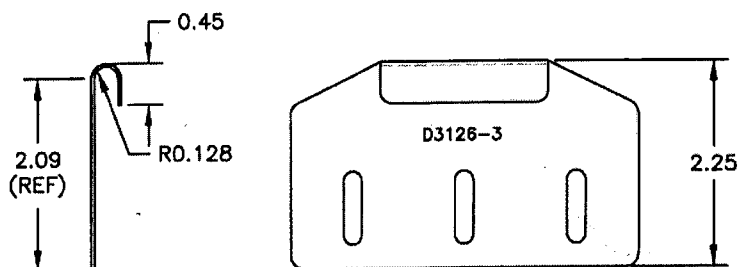
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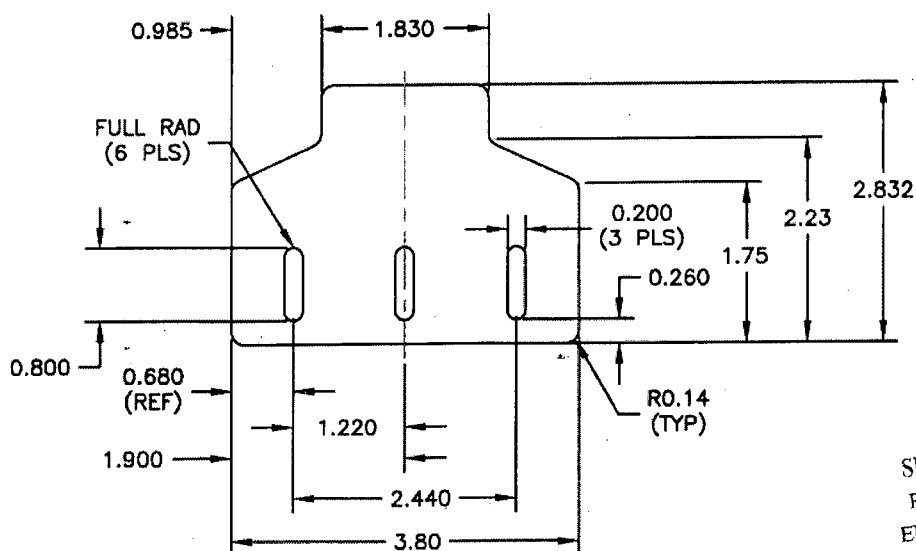


DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3126	REV. A SHEET 2 OF 3
DATE 02.04.17		TITLE BRACKET	SCALE 1:2

RELEASED
02.05.27 #



D3126-3 BRACKET
REPLACES PREMIER P/N B30-23000-267



D3126-3 BRACKET FLAT PATTERN

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31894

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-3 AS SHOWN

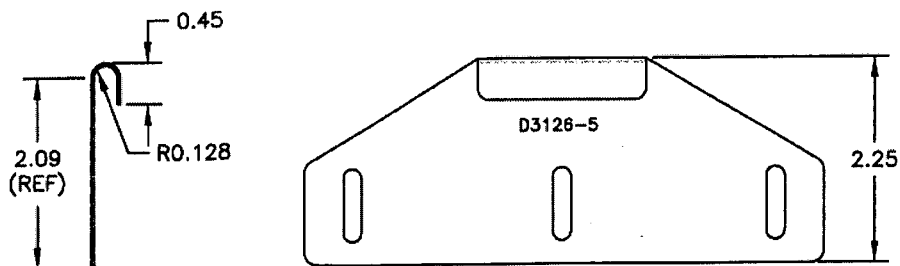
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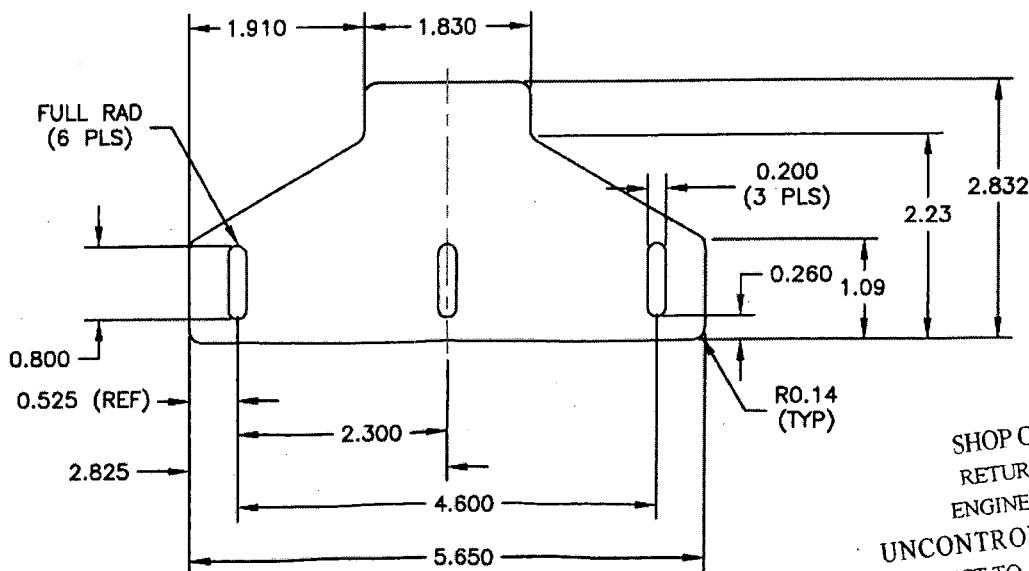


DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3126	REV. A SHEET 3 OF 3
DATE 02.04.17		TITLE BRACKET	SCALE 1:2

RELEASED
02.05.27 #



D3126-5 BRACKET
REPLACES PREMIER P/N B30-23000-269



D3126-5 BRACKET FLAT PATTERN

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31894

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-5 AS SHOWN

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DART AEROSPACE LTD		Work Order: 31894
Description: Bracket		Part Number: D3126-1
Inspection Dwg: D31261 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.830	+/- 0.010	1.838	✓		Vern	
B	2.832	+/- 0.010	2.832	✓		Vern	
C	3.000	+/- 0.010	3.010	✓		Vern	
D	1.925	+/- 0.010	1.932	✓		Vern	
E	1.500	+/- 0.010	1.509	✓		Vern	
F	0.976	+/- 0.010	0.980	✓		Vern	
G	0.524	+/- 0.010	0.530	✓		Vern	
H	0.800	+/- 0.010	0.802	✓		Vern	
I	0.200	+/- 0.010	0.195	✓		Vern	
J	0.260	+/- 0.010	0.265	✓		Vern	
K	0.032	+/- 0.010	0.034	✓		Vern	
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: JAD	Audited by: CJ	Prototype Approval:	N/A
Date: 07/06/14	Date: 07/06/14	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved